



DASH NUMBER	TUBE OD NOM	B STRAIGHT THREAD	C HEX FLAT: NOM	D DIAMETER		L <sub>3</sub> ±.020	T REF
				BASIC	TOLERANCE		
B2	1/8	5/16-24UNF-2A	7/16	.062	±.003	.700	.220
B3	3/16	3/8--24UNF-2A	7/16	.125		.730	.220
B4	1/4	7/16-20UNF-2A	1/2	.172		.800	.220
B5	5/16	1/2-20UNF-2A	9/16	.234		.800	.220
B6	3/8	9/16-18UNF-2A	5/8	.297		.840	.250
B8	1/2	3/4-16UNF-2A	13/16	.391	±.004	.940	.250
B10	5/8	7/8-14UNF-2A	15/16	.484		1.100	.310
B12	3/4	1-1/16-12UN-2A	1-1/8	.609		1.280	.380
B14	7/8	1-3/16-12UN-2A	1-1/4	.718	±.005	1.310	.380
B16	1	1-5/16-12UN-2A	1-3/8	.844		1.330	.380
B20	1-1/4	1-5/8-12UN-2A	1-11/16	1.078	+.008 -.005	1.450	.460
B24	1-1/2	1-7/8-12UN-2A	2	1.312		1.650	.530
B32	2	2-1/2-12UN-2A	2-5/8	1.781		2.050	.680

## NOTES:

- MATERIAL:** Steel, carbon in accordance with procurement specification.  
Steel, corrosion-resisting in accordance with procurement specification.
- PROTECTIVE COATING:** Cadmium plated in accordance with procurement specification.  
Zinc plated in accordance with procurement specification.  
Phosphate coating in accordance with procurement specification.  
Passivation treatment in accordance with procurement specification.
- DIMENSIONS AND TOLERANCES:** Dimensions and tolerances not shown shall be in accordance with the SAE Standard for 37 Degree Flared Fittings (SAE J514).
- THREADS:** Threads shall be in accordance with Screw-Thread Standards for Federal Services, Handbook H28.
- PART NUMBER:** The MS part number consists of the MS number plus the dash number.  
A. For cadmium plating use the MS number, plus the dash number.  
Example: MS51518B2.  
B. For zinc plating add (Z) to the dash number. Example: MS51518B2Z.  
C. For phosphate coating add (P) to the dash number. Example: MS51518B2P.  
D. For corrosion-resisting steel, add (S) to the dash number.  
Example: MS51518B2S.
- For design feature purposes, this standard takes precedence over procurement documents referenced herein.
- Reference documents shall be of the issue in effect on date of invitations for bid.
- The illustration is for identification purpose only and is not intended to restrict designs on shapes not dimensioned.
- After 17 January 1979 bodies will be used for production only and **SHALL NOT** be stocked for maintenance. Existing stock of bodies should be used until depleted.

P.A. AR

Other Case OS

TITLE

PLUG, MACHINE THREAD, 37° FLARED

MILITARY STANDARD

MS51518

PROCUREMENT SPECIFICATION  
MIL-F-18866

SUPERSEDES:

SHEET 1 OF 1